



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D3403-3

Job Sheet 170272



Part No: D3403-3

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-03-07 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign Off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time		
90	Start up Operation	20 Ea		1/25/18	0.00	0.00	Start Up Machining-2			23
100	Hardinge	20 pcs		1/26/18	0.02	2.43	Hardinge			9-89
120	QC	20 pcs		1/26/18	0.00	0.00	QC8			<i>ST033</i>
130	Packaging	20 pcs		1/26/18	0.00	0.00	Packaging3-1			<i>ST033</i>
140	QC21-SA	20 Ea		1/26/18	0.00	0.00	QC21			<i>ST033</i>

Part Op Descriptions: 100 - 1- Turn as per Folio FA558 & Dwg D3403 Folio Rev: ____ Dwg Rev: ____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.750	4	14	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	2.165inches + 0.010 - 0.000	2.175 2.165		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257		
4	Bushing	0.750inches ± 0.010	0.760 0.740		
5	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
6	Bushing	0.313inches ± 0.010	0.323 0.303		
7	Bushing	60.0Degrees ± 0.5	60.5 59.5		
8	Bushing	0.010inches ± 0.010	0.020 0.000		

QA Clos

Work

P:

N:

Date :

DART

AEROSPACE

S036516



Bushing

PART NO: D3403-3
Original Serial #: S036516
Revision:
Operation: Start up Operation
Change No:

01/29/18
Job No: 170272

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DATE

AEROSPACE

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Contamination	☐	Out of Sequence	☐	Part Moved	☐
Countersink	☐	Off-set	☐	Drawing	☐
Cut Too Short	☐	Mislabeled	☐	Finish	☐
Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER :